

Date: Monday, 08/09/2008 2:50:47 PM
User: Julie Lepocq

Process Sheet

SPAIT--

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 41890
Estimate Number : 11175
P.O. Number :
This Issue : 08/09/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 39717
Written By :
Checked & Approved By : JLD 08.9.08
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM
EstRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Drawing Name : TUBE
Part Number : D22825
Drawing Number : D2282 REV E
Project Number : NA
Drawing Revision : E
Material :
Due Date : 30/10/2008

Qty: 58 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R0750

304 SS Roundbar .750



Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s)
Material: AISI 304 Stainless Steel 00.750(M304R0.750)
Batch M109421

J.F.

08/10/23

(58)

2.0

DOOSAN LATHE

DOOSAN LATHE



Comment: DOOSAN LATHE
1-Turn as per Dwg D2282 and Folo FA189
2-Deburr

J.F.

08/10/23

(58)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F.

08/10/23

(58)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F.

08/10/24

(58)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: (MISC)

J.F.

08/10/27

Date: Monday, 08/09/2008 2:50:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 41890

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

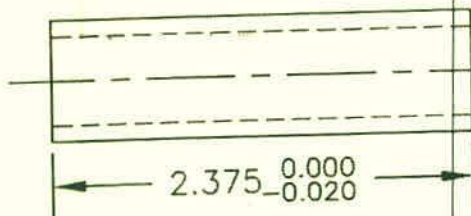
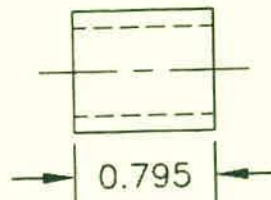
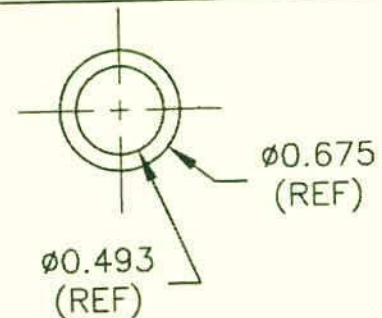
Job Completion



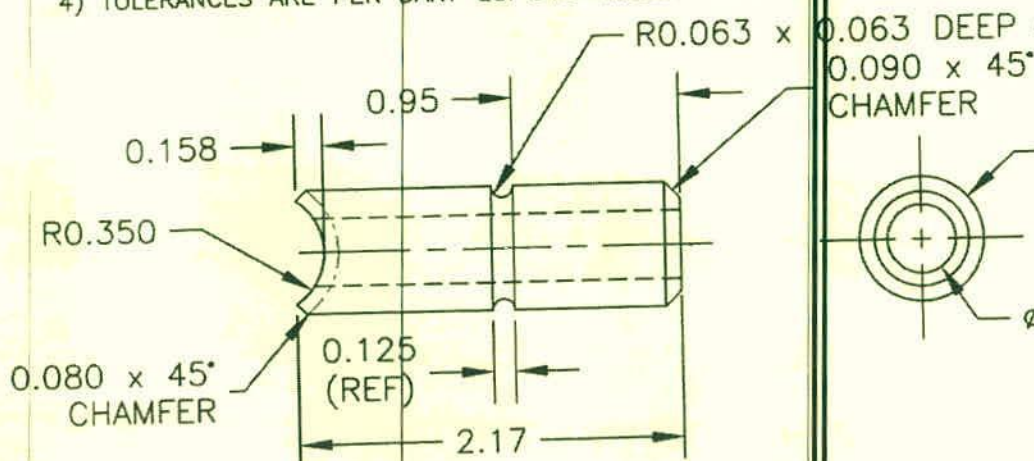
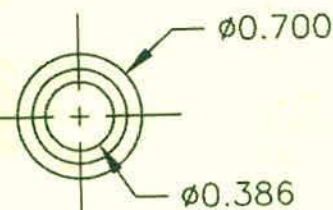
WLF 08-10-27

DARTRELEASED
05/09/16

DESIGN BW	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

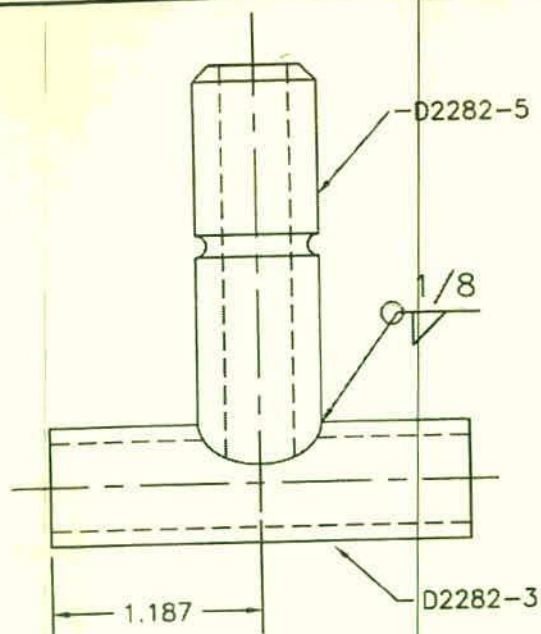
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47890

Copyright © 1994 by DART AEROSPACE LTD

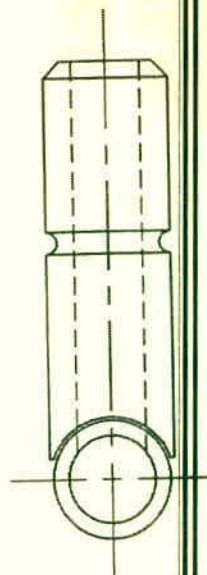
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

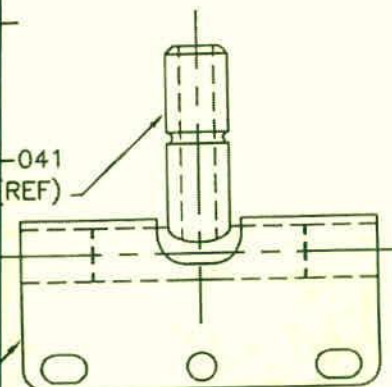
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



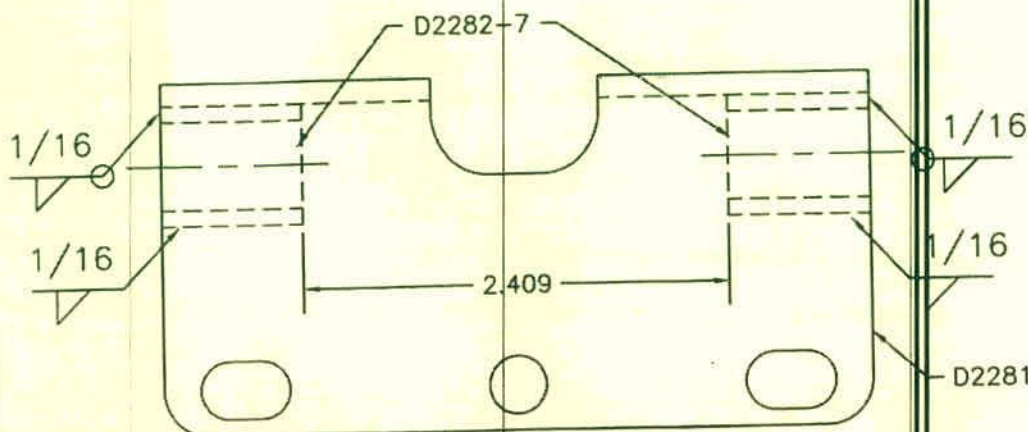
D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41890

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

